

Ō

MAGNETIC CRITERIA...

...multiple product grades and complex flux patterns are available with the use of Plastiform magnets.

POLE CONFIGURATION...

whether single pole or double pole or even alternating multipole on a single sheet, 3M Company can provide the exact configuration for your specifications.

FLUX PATTERNS...

with minimum reluctance in the magnetic circuit can be custom designed by 3M Company to meet critical tolerance requirements.

ENERGY ..

the ferrite particles in Plas form magnets are high oriented during processing to provide magnetic properties equal to, or superior to conventional isotropic ferrimagnets. This formulated decreases the chance demagnetization or flux participal changes during handling and operation.

	UNITS	Р	LASTIFOF	RM
	1:CGS-U.S. units 2:SI (MKSA) units	(PL-1)	(PL-1H)	(PL-1.4H)
MAGN	ETIC PROPERTIES (LY	pical)		
Maximum energy product (at 23°C) (Bd Hd max.)	gauss a cersteds x 10° tesias x amp, turn/m x 10°	1,08 8.57	1,10 8.73	1.4 11.1
Residual induction! (Br)	gauss millite stas	2150 215	2150 215	2450
(at 23°C) Coercive Force' (Hc)	cersteds ampere-turns/cm	1650 1315	1940 1545	2200 1950
(at 23°C) Coercive Force intrinsic ^s (Hci)	persteds ampere-turns/cm	2150 1710	3000 2385	3000 2385
(at 23°C) Incremental permeability	ratio	1.08	1.08	1.04
(at 23°C) Thermal coefficient of	% per *F	0.105 0.19	0,105 0.19	0.105 0.19
magnetization (-40 to 120°C) Thermal coefficient of intrinsic	% per 'F	0.12 0.22	0.07 0.13	0.07 0.13
coercive force (-40 to 120°C) Peak magnetizing force required	oersteds ampere-furns/em	10000	10000 8000	10000 8000

TEST METHODS: 1-Pole-coll Hysteresigraph



	UNITS CGS-U.S. units SI (MKSA) unils	PLASTIFORM VALUES
PHYSICAL PROPERTIES (typical)		
Density ² (at 23 °C)	lbs/in³ gm/cm³	0.134 3.71
Hardness' (at 23°C)	Shore D	55
Tensile strength* (at 23 C)	psi N/cm³	640 440
Flexibility ^a (al 23 C)	180° bending on mandrel with O.D. equal to 7X sample thickness	Pass:
Volume resistivity (at 23 C and 50% R.M.)	ohm-cm	1016
Dielectric Strength' (at 23 C and 50% R.H.)	volts/mil kV/mm	250 10
Thermal coefficient of thickness expansion (4 to 120 C)	mil/mil per F	9.8 x 10 ° 18 x 10 °
Maximum continuous operating temperature	F C	250 120

Typical Chemical Resistance (Nitrile Rubber Binder)

"All values shown are averages and not intended for specification purposes.

Specification values will be provided upon request

"Good - minor or no effect; up to 10% swell in thickness Fair - moderate effect; 10-25% swell in thickness
Poor — severe effect; greater than 25%

swell in thickness

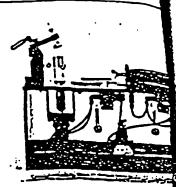
hettotwance	
Good	
Good	
. fair	
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Poor	
Poor	
· Poor	
Fair	
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	-
	Good Good Good Fair Fair Fair Fair Good Good Good Good Good Foor Poor

Applications Continued....



The magnetizer-inserter equipment shown to the right illustrates the principles of automated production using Plastiform Brand magnets. These principles are easily applied to modern manufacturing processes and are designed to save production time and drastically reduce rejection rates without sacrificing performance. The magnetizer-inserter and other application equipment can be fabricated by a machine builder, or in the manufacturer's own tooling department. 3M Company's Customer Engineering Service is available to provide the technical assistance necessary to get such equipment built and into operation.

郊沙



A widely recognized advantage Plasiform material is its adapta to automated magnetization-in

Units 1. CGS/U.S. 2. SI(MKSA)

Typical Physical Properties @ 23°C (73°F)	S
(a) 23 $(13$ $1)$	

*All values shown are typical and not for specification purposes, 18-1013 and 8-1030 are labrication type and extra-flexible type respectively.

保護室(2)(存加) 现所往往 风险的在膀胱结束

建饱史目 险放工限

Hardness' Tul /2	55 Shore D 3 以之人: :
Tensile Strength 12/13/27	1, 540 PSI 2, 440 N/cm*
Elongation' (8-1030 only) KPSKK	18%
Flexibility (B-1030 only)	Pass — 420° bending on mar equatio 7 x sample thickness
Section (50% BH)	1010 Ohm-cm
Volume Resistivity* (50% R.H.) Dielectric Strength* (50% P.H.)	1. 250 volts/mil 2. 10 Kv/mm
Thermal Coefficient of Thickness	1. 9.8 x 10° mil/mil-per °F 2. 18 x 10° cm/cm per °C
Expansion (4° to 120° C) Maximum Continuous Operating Temperature	1. 250 °F 2. 120 °C
D 207	· 3M Test Method

Valua*

1. 0.134 lbs/in*

2_3.71 gm/cm³

Test Methods

- 1 , STM D-297 2 ASTM D-2240 (10 sec. delay)
- ASTM 0-412

Property

Density'

- ASTM 0-257

ā N

Determination of Typical BH

·All values shown are averages and not intended for specification purposes. Specimostion values will be provided upon request.



ġ	auss 2450	tesla 0.2450
•		
	B ₄ 2000	0.2000
		(B _d H _d) max
	B₅	\ \\ \\ \\ \\ \\ \\ \\ \\ \\ \\ \\ \\ \
	1000	7.
	Ha	Type 1.4h
1 H _d	1	0 11.1 x 10° tesla
1.75 x 10° A/m Demagnetizing F	orce t	i B _o
		

(公路7.1点9元)

Acids, Inorganic (HCI, H,SO.)

Typical Chemical Resistance (Nitrile Rubber Binder)

All values shown are everages and notificated for specification purposes.

Specification values will be provided upon request

**Good — minor or no effect; up to 10% swell in thickness
Fair — moderate effect; 10-25% swell in thickness
Poor — severa arreat; greater than 25%

thickness
Poor — severe effect; greater than 25%
swell in thickness

Chemical (7 days immersion @ RT)	Performance**	<u> </u>
	Good	
Motor OII FUID	Good	
Transmission OII 河南的	Good	
Hydraulic Fluid 主任任 图 (1)		. :
Kerosene 大艺	Good	
JP-4 Fuel ne this	fair	
Gasoline Lib	.Fair	1. 117. 271
Heptane PKE	Fair	
Antifreeze "Artal	Good	
Ammeeze	Good	
Turpentine 44310	Good	
	Good	1 777
Water St.	Good	TAX
Detergents 317 m	· Good	
Salt Spray 32h		15
Aromatic Hydrocarbons	Poor	46.34
	E (1 200)	
(Carbon Tetrachloride, Trichloro- ethylene)	12 t 5 LOOI	
(Carbon Tetrachloride, Trichloro-		
ethylene)	Poor . ·	57.00
Ketones . KA EE	Fair	
Alcohols (DV)		
	Pont	

Poor

受机的程

A cetyl

Delacace oroto

经济部 力央標準局

ypical Magnetic Properties @ 23°C (73°F)

"All values shown are typical and are not intended for specification purposes. 8-1013 and 8-1030 are labrication type and extra-flexible type respectively.

Units 1. CGS/U.S Value* Property 1. 1.4 x 10° gauss x persteds Maximum Energy Product (B, H, max) 2. 11.1 x 103 teslas x amp turns 是大大学练 Aesidual Induction' (B.) 2英语名紅山東流 1. 2450 gauss 2. 245 milletesias

Coercive Force' (Hc)

1. 2200 persteds 2. 1750 ampere turns/cm

2 SIMKSA

(1

Coercive Force, Intrinsic' (He) 图片银矿 1. 3000 persteds 2. 2385 ampere turns/cm

语写真在就像最 Wincremental Permeability

1.04 ratio

Thermal Coefficient of Magnetization [Heversible)

1. -0.105% per °F 2 0.19% per °C

(乌连) 固有保险为侵及债务 Thermal Coefficient of Intrinsic

1. 0.07% per °F 2. 0.13% per °C

Peak Mi-gnetizing. Force Required

1. 10,000 perstads

的高支帝强化力

(23) 石东心温度/学教

2. 8000 ampere turns/cm

Test Methods

Pole-coll Hysteresigraph

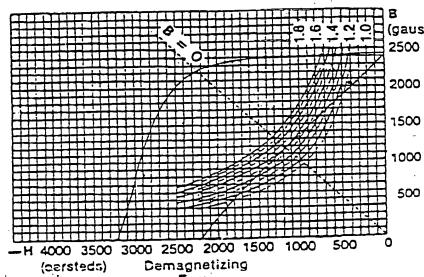
Typical Demagnetization Curve @ 23°C (73°F)

"All values shown are averages and not inlended for specification purposes. Specification values will be provided upon request.

2L-1.4H

2450 gauss 2200 oer. 3250 eer. BH max 1.40 G.O. x 10

Typical Demagnetization Curve



Force

業材料研究所編譯資彩

整濟球貨料來源: 電波折開 74.9.12 23.24.25 版

资料分额:

N

平日初:74年11月5日 -(MR74-140)

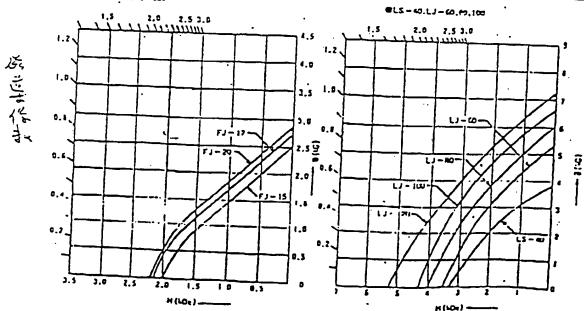
市場一金属

题:型修磁磁之技好物向與未來

表】 型厚磁纸之特性

~	11 3	2	ferrite	 -					
W.	B A 6			<u> </u>	J	14	± (14 &	
	RSURERS		F J - 17	71-20	L S -40	L J -60	LJ-80		
	-	2.3-2.5	2.5~2.7	2.7-2.9	3.0-4.0	4.3-5.3			レノー!>
z n	स्याद अरू	1.8-2.2	2.0-2.4	2.0-2.5	2.5-3.5	3.2-3.0	5.3-6.1	6.1-6.7	6.7~7.3
	- 11 M	2.5-3.5	2.5-2.5	2.6-2.5	>5.0		2.8-4.2	4.0-4.4	4.4-5.3
1 43	D大 記 に 11CD.	1	1.5-1.7	1.7-2.0	2.5-3.5	· >5.0	>5.0	>5.0	>5.5
	可思導回用meec	1.0-1.2	1.0-1.2	1.0-1.2	+	4.0-6.0	6.0-R.0	8.0-10.0	10.0-12.
	जाराह हो जा छ	-0.18	-0.18		1.0-1.2	1.0-1.2	1.0-1.2	1.0-1.2	1.0-1.2
	tt E	3.5-3.7		-0.18	-0.05	-0.05	-0.0%	: -0.05	
`		+	3.5-3.7	3,5-3,7	\$.0-5.5	5.0-5.5	3.0-5.5	5.0-5.5	-0.03
	IE 1	100-120	100-120	100-130	30-40	Ø−70	60-70		8.3-5.8
	12 14 18 18 18 18 18 18 18 18 18 18 18 18 18	[1ecre-11 4]	(xoc===11 P)	(acce_11 #)	(zio-e-, p)			.60-70	60-70
12		(CO) - 700	500 ~ 700	600-700	30-70	300-300	it mennett it	(3-11.2)	(Boding 12
12	<u>A 12 22 22 22 22 22 22 22 22 22 22 22 22 </u>		1	1	30 - 50	100-300	200-700	500-300	150-250
	15 B 17 12 14	1100-1200	1100-1200	1100-1700					
-)	二世族。其日代	10	1010-	10-4-10-4	1010	CO0 - 1/LD	(D-00	200-100	Zn-30
ļ	中区四十二十四日日	10'-10'	10'-10	10'-10"	10 - 10-4	10-1-10-1	10-4-10-4	1010-	10-,-10-,
\perp	可尽温度生	150	150						
	#II			180	100	120	120	150	120
	2 12			Magnet 1 cd	547	Mishle-cia	miyeelde K	potyantile g	
_		A: Us	्य छ	को ध्र	roll	31 111	11 11	11 13	Divado K

OFJ-15.17.20



.ferrite 系型形磁纸证 图 2 碰的锭(代表)

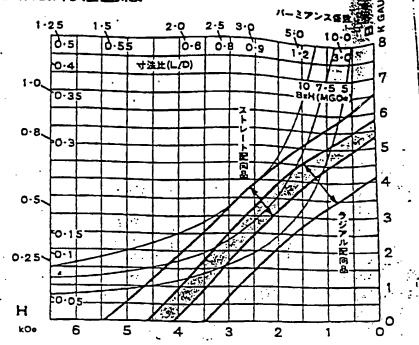
桥土新条型路碰纸造磁 四 3 山烧(代表)

■特 長

- 軽く、われにくく、特殊形状のものも容易に製造できます。
- 項密成形ができます。(寸法精度±0.03% 以下)
- インサート・アウトサート成形等。他の 図材との一体成形が可能です。
- ラジアル配向・多極審磁も可能です。
- 通常の工作機械で容易に加工できます。
- 結合樹脂の選択により、フレキシブルタイプもあります。



■減磁特性曲線



置磁気的特性·物理的特性

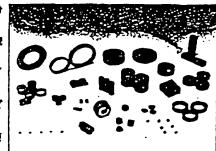
MAGNETIZING DIRECTION

	·	· · · · · · · · · · · · · · · · · · ·	radial	straight
	記号	単 位	ラジアル配向品	ストレート配向品
最大エネルギー積	(B·H)max	MGOe	4~8	6~10
残留磁束密度	Br	G	4,200~5,900	5,300~6,600
保磁力	вНс	Oe	3,500~4,600	4,200~5,400
固有保磁力	2Hc	Oe	>8,000	>8,000
Brの温度係数		%℃	0.035	-0.035
使用温度範囲		C	-40~150	-40~150
密度	đ	g/cm²	5.5~5.7	5.°~5.°
硬 度	HROCK	Rスケール	100~120	100~120

圖用 途

小型化、軽量化、高性能化が要求される分野に最適です。

- 回転破器(各様小型モーター、小型発程機等)
- 計測・通信視器(センサー、リレー、スイッチ、メーター等)
- -* 管質機器(スピーカー、マイクロホン、ピックアップ、イヤホン等)
- ○応用機器(マグネットカップリング、健康 機器、装飾品、粒子ロック、玩具 等)



置サンブルをご希望の場合

切削加工用材料は豊富にとりそろえてあり即納いたします。

(評細はサンプル表をご参照下さい。)

ASSES AND PROPERTIES

NAKANO PERMALLOYS are nickel iron alloys which meet the requirements of miniaturized, electromagnetic devices. You can get a strong magnetic flux through week electric Current.

NAKANO PERMALLOYS are suitable for several shaping They are well blanked, well drawn, well bent, well welded and well rolled to thin sheets, Whatever shape it may be, you can make it from NAKANO PERMALLOYS. Thin sheets make it possible to diminish eddy current and to miniaturize devices.

NAKANO PERMALLOYS are available in any shape you want. Send us the drawing of a component and you will get it made of Permalloy already heat treated.

NAKANO PERMALLOYS are prepared in accordance with JIS. Our products are based on Japan Industrial Standard c 2531. We can supply uniform alloys in production quantities and at any time you want. Besides the standard products, we produce a number of special grade for unusual applications.

NAKANO PERMALLOYS are used for such devices as transformers for telecommunication, taperecorder heads and shields, light and sensitive relays, solenoid cores, several types of magnetic shield and detectors in ground falt circuit interrupters.

Remark. About shielding, more informations are offered from page 3 to 5.

Table 1. Thickness and Tolerances of Sheets and Strips

			Unit . me
Thickness	loimance an shickness	Thickness	Tolerance on thickness
0.0\$ 0.1 C 2	=0.003 =0.01 =0.01s	0.35 0.5 1.0	E0.03

Table 3. Magnetic Characteristics of PB Initial Personalist. Idepretic Characteristics عبدا سند ion flux den مؤنية لهذو يب Hi He (0=) 3 m (C) & (G) #8<= MAKANO PERMALLOY 3000-5000 15000-70000 0.15----14500-- 15500 45--J 1 5 -3000aia 30000min 0,20max 14000min 45-4

Remorks is the initial permeability at the field strength 0.01 Oe.

He is the coersive force when magnetized at 100e and reversed.

Br is the residual magnetic flux when magnetized at 10 Oe and reversed.

Br is the value for informative reference.

Table 4. Effective Permeabilities of PB

CL.,	Thickness (mm)	Effective Formability see	No O'MHE	μο 'IEMg
		NAKANO PEMALLOY	4000-4500	2002-2000
78	07	2 (\$	-2000min	2400-in.
	0 35	NAKANO PERMALIOT	3500-4600	2300-3000
		J 1 \$.	2000	2700ma.

V-PB- is 45% nickel iron alloy with the biggest satural induction among the Permalloys.

It costs less than PC and mainly used for transform for telecommunication, choke coil cores, sensitive rela sulenoid cores, D.C. incremented transformers and device in alternative current equipments.

"PD" is 36% nickel iron alloy with slightly lower magnet properties, but it offers the highest electric resistivity of ; AC-cm among the Permalloys. PD is mainly used for transformers for relatively high frequencies.

PC is 78% nickel iron molybdenum alloy. It is th most effective material for sensitive and miniaturized electroni devices, because of its highest permeability, the lowest coersing force and the smallest core loss.

PC's thin sheets are profusely used for taperecorder heads transformers of high grade and several shielding device required extremely weak magnetic field.

PCS is called supermalloy which has the permeability about twice as much as normal PC, and its coersive force is under 0.01 Oe. PCS is usually used for the spiral wound tape core in a ground fault circuit interrupter.

Table 2. Classes and Naminal Components

tlen	Noninal Component	lonati
PL PC PD	NI40-50% For removal NI70-80% including other special components NI30-40% For removal	45 fermaliay 78 fermaliay 36 fermaliay



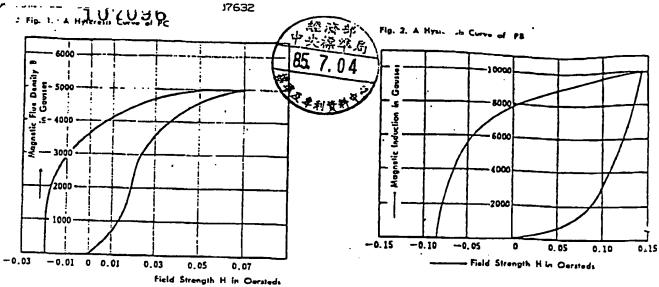


Table 5. Magnetic Characteristics of PC

Cless	Magnesic Characterizies	Inhial Permeability	Maximum Permeability	Country targe Hc (Co)	Seturation flux density Bio (G)	Residuel flor density Br (G)	residicity M2≺m
,,	NATANO PERMAILOT	40000 1.500000	120000-300000	0.070mg c	4500	4000mer.	SS-sia.
	3 . I S	25000min.	100000min.	0.0ZSmat,	6500min		SS-in.

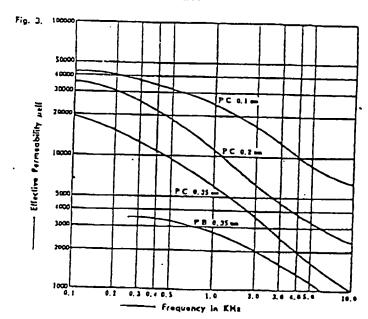
Remarks 1. 21 is the initial permeability at the field strength 0.005 Oe.

- 2. He is the coersive force when magnetised at 10 Oe and reversed.
- 3. Bio is the saturation flux density when magnetized at 10 Oe and reversed.
- 4. Br is the value for informative reference.

Table 6. Effective Permeabilities of PC

Cless	Thinctmiss (mm)	Elloctive Parmoability µ e	## QJ KHz	ue 1 EHz	µ+ 3EM2
	0.7	MALANO PERMALLOY		25000 – 35000	10000 - 14000
		. 1 1 5		Z222	7000mm.
rc		HARANO PERMAILOT	25000 - 35000	10000-13000	
- 1	دد.ه	NAKANO PERMANDY	, 70000min,	BCCComin.	
		1 1 5	12000 — 1.5000 10000 — 1.5000	\$500 = 7 500	

Remark. Measuring current is 0.5 mA



Specimen: Ring core outside diameter 45mm inside diameter 33mm

Annealing: In hydrogen atmosphere 1100℃×2hr.



FLEXIBLE WIDE SHEET MAGNE

THE ULTIMATE IN VERSATILITY!

PROPERTIES/APPLICATIONS

Flexible Magnetic Sheets are being used for signs, displays, ulsual aids, toys, games, premiums, magnetic business cards, bulletin boards, indoor and outdoor advertising boards and many other applications. No matter what size or shape you use, the entire surface is magnetic and flexible. It will conform to smooth contours. Since you can cut Flexible Magnetic Sheet with ordinary knives, scissors or dies, you need not worry about expensive cutting equipment.

Consult us concerning any custom te quirements you may have. Special thickness, width and colors are available with quantity usage.

· Available with or without winyl facing with or without pressure sensitive back-

· All dimensions in inches

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Ø

G

 Typical magnetic strength on bare metal is 55 lbs. per eq. ft. for .030 thickness and 35 lhs. for .020 thickness.

Shipped 24" wide by length

· Fuil 100 ft. roll may contain up to three sections, none less than 20 ft. long

Cat. No. Dimensions Standard Colors TO PROPERTY. 8221 020 × 24-Plain brown/adhesive 8223 .020 × 24-Semi-gloss white 8320 .030 × 24-Plain brown 8322 .030 × 24° Matte white 8324 .030 × 24-High-gloss white 8620 .060 x 24-Plain brown

CAN BE USED WITH

ENAMEL, VINYL AND POLYESTER SILK SCREEN INKS -- CAN ALSO BE LETTERED WITH BULLETIN AND

LETTERING ENAMELS. THE FULL MAGNETIC SHEET

WITH VINYL FACING IS BEING USED

EXTENSIVELY FOR

MAGNETIC SIGNS

Typical Properties

MATERIAL	RESIDUAL FLUX DENSITY BR (GAUSS)	COERCIVE FORCE Hc (OERSTEDS)	MAXIMUM ENERGY PRODUCT BHmax (MGOs)	MAXIMUM PRACTICAL OPERATING TEMPERATURE (*CI/(*F)	TEMPEHATURE COEFFICIENT (% LOSS/°C)	DENSITY (LBS/QUBIC INCH)
FLEXIBLE REGULAR	1600	1370	0.6	120/248	.19	.133
FLEXIBLE HIGH FORCE	2100	1370	1,1	120/248	.19	.140

· Other thicknesses available

· Higher maximum energy product, available



WRS. 75 ES.



107096

◎吸引力之計算

四岁另院少之四既采西

和(g/cm³)

3.9

f (dyne) = a. β¹/8π ……… 斯姆次面制

(D)对光原用:…… 980(dyne)

● 特性表 (CHARACTERIZATION) 成之永久性田石。 **CBARIUM FERRITE COMPOSITE**) 面 保助永久虽然,张以和沙战合则最化合物

就政特性曲鏡 (DEMAGNETIZATION CURVE)

姚 方性

-H taminds! õ 戏胆少 DEMAGNETIZATION FORCE 1200 8 8 ŝ 8 ફ ğ 8 Š \$ 出来名はSunaucTion

斯斯爾 oersteds

カ(Hc

1900

1300

2200

1650

0. 6A

是Sussement (Br

松大他所即(BH)

Characterization

符

訊

级方世

等方性

图有保留力(Hci)

oe rsteds

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2460

ス 元 記 記

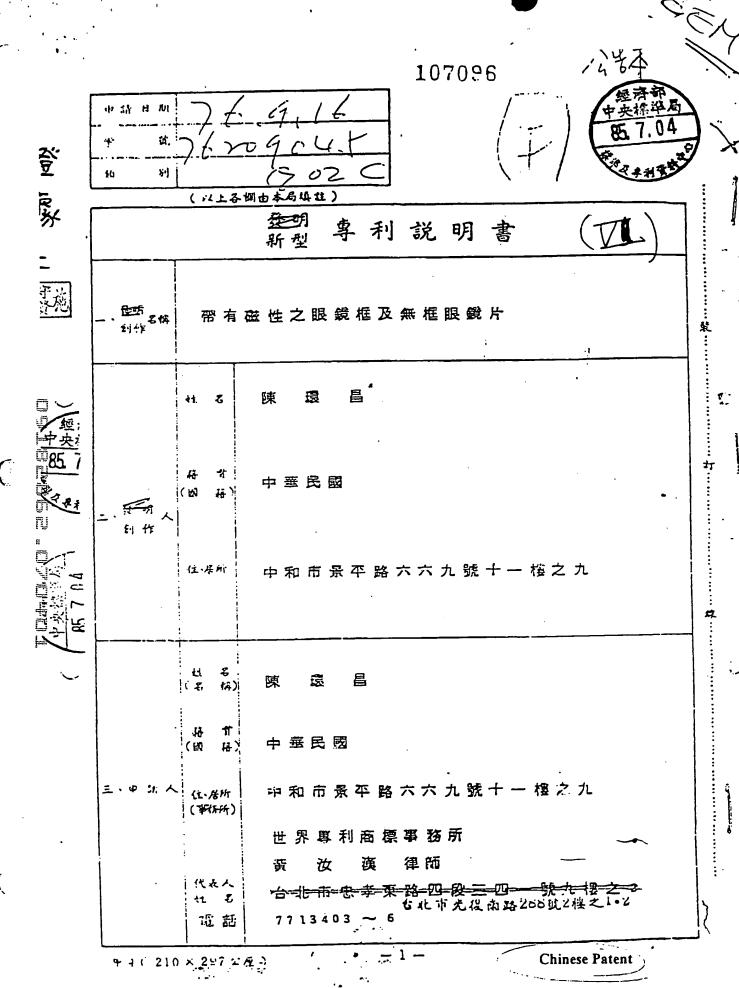
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<u>ا</u>.

7月期報 6 阳化形成: MAGNETIZATION 一個的組化 2 强组化

COHOMON "CYCHOH



107096 學濟部 中央標準 85. 7. 0 4)osiase...oroi

107096 經濟部 中央標準 85.7.04 TOHOZO" GABABA

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